



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-751-011
Job Sheet 179635



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 8/2/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S091464



Part: D135-751-011

Job No: 179635

Serial No/Batch: S091464

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 15/10/20, TC LoA RDIMS-9661680-v1 14/07

rials

S091464x1

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/2/18	0.00	0.00	Start Up Skid tubes-1		DD
120	Skid tubes	1 pcs		8/2/18	0.00	0.80	Skid tubes-1		DD DAS
140	QC	1 pcs		8/2/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs		8/2/18	0.00	0.33	HandFinish1		SA 18-08-23
160	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		M66
170	Skid tubes	1 pcs		8/2/18	0.00	1.00	Skid tubes-1		DD
180	QC	1 pcs		8/2/18	0.00	0.00	QC10		DD 13-03
185	HandFinish	1 pcs		8/2/18	0.00	0.10	HandFinish6		SA 18-08-1
187	QC	1 pcs		8/2/18	0.00	0.00	QC7-1		M66
190	Skid tubes	1 pcs		8/2/18	0.00	0.77	Skid tubes-1		DD
200	QC	1 pcs		8/2/18	0.00	0.00	QC5		DD 15-08-03
210	HandFinish	1 pcs		8/2/18	0.00	0.08	HandFinish2		SA 18-08-03
215	Outsource	1 pcs		8/2/18			ATE003-VC	5	N/R
220	SprayPaint	1 pcs		8/2/18	0.00	0.25	Spray Paint		SEP 09 2018
230	QC	1 pcs		8/2/18	0.00	0.00	QC14		SEP 11 2018
260	HandFinish	1 pcs		8/2/18	0.00	0.74	HandFinish4		BER 18-08-03
270	QC	1 pcs		8/2/18	0.00	0.00	QC5		SEP 11 2018
280	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging1-1		9-89
290	QC	1 pcs		8/2/18	0.00	0.00	QC4		666
300	Packaging	1 pcs		8/2/18	0.00	0.00	Packaging3-1		666
305	DC	1 pcs		8/2/18	0.00	0.00	DC		21
310	QC21-FG	1 Ea		8/2/18	0.00	0.00	QC21		SEP 14 2018

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507. and section G-G to .750" (2 places) 2- Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 138862 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138914

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: M138935

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5089120
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077418
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	5105604
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5071543
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5084558
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5083322
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5083326
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5082687
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058138
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5045668
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5095223
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5095214
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071664-2
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126369
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5090814
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5091848
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5089854
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5089866
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5081647
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5081645
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5071663
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5092499
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5057659
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5090636
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	509370
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5104354

M.U. 005367

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	0	0
170-Skidtubes	D3504-1	2	28	0
	D3504-3	1	26	0
	D3504-5	2	14	0
	D3505-1	1	4	0
190-Skidtubes	D3506-1	4	17	0
	D3506-3	2	8	0
	MS20601-AD4W3	12	1,163	0
260-HandFinish	ALS4-1032-225	1	4,460	0
	ALS7-1032-130	38	1,389	0
	AN3C4A	31	1,807	0
	AN3C5A	2	1,655	0
	AN526C1032R10	2	178	0
	D2965	1	80	0
	D2965-3	1	30	0
	D3492-1	4	272	0
	D3492-3	4	103	0
	D3492-7	2	35	0
	D4918-047	1	8	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	9	0
	NAS1149C0332R	33	5,349	0
	NAS1611-007	2	286	0
	NAS1611-010	4	453	0
	NAS1611-013	4	349	0
280-Packaging	AN3C4A	8	1,807	0
	D3512-041	2	15	0
	NAS1149C0332R	8	5,349	0

Part Specifications

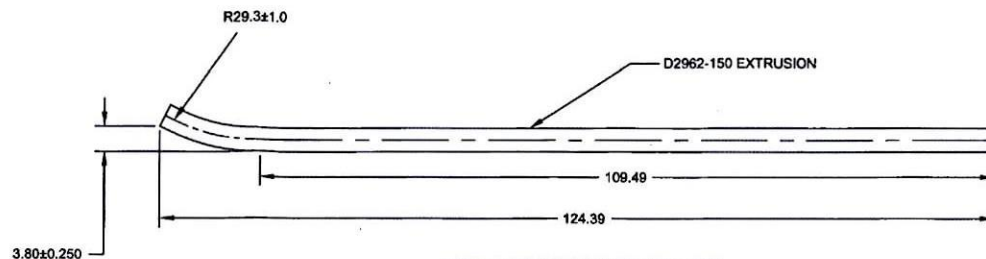
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Plex 6/20/18 1:07 PM dart.white.jesse

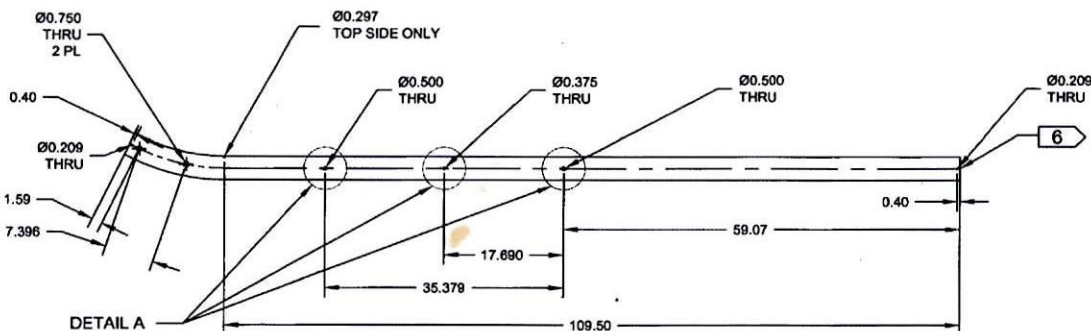
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3482-041	PLUG ASSEMBLY
4	D3482-043	PLUG ASSEMBLY
2	D3482-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

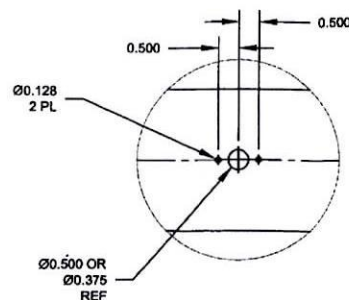
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL

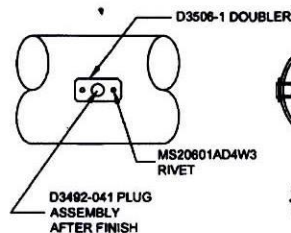


D3507-1 DRILLING DETAIL

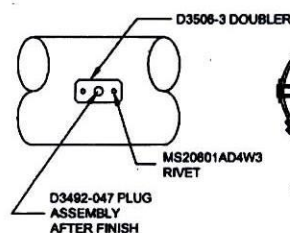


DETAIL A
TYP. 6 PL
SCALE 3:10

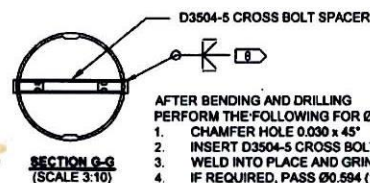
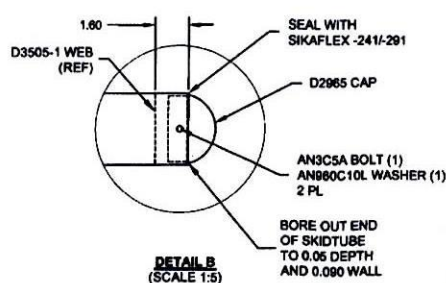
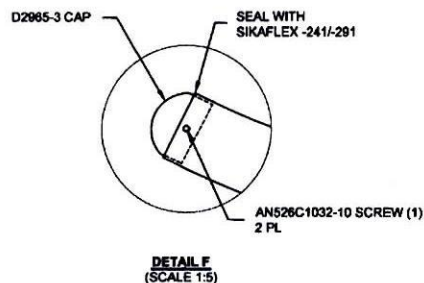
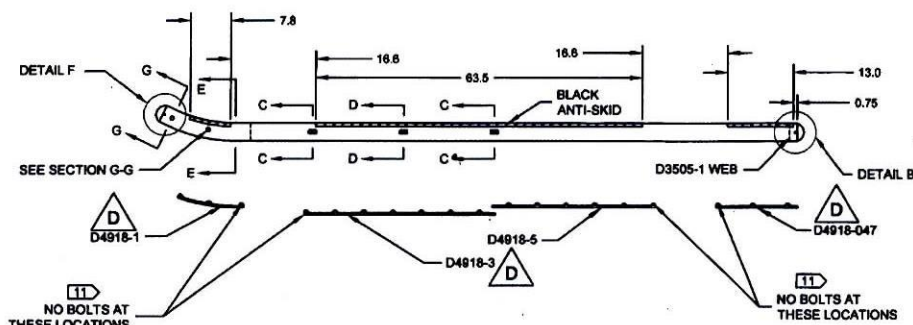
D	REMOVE D3568-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	UP	DRAWING NO.	REV. D
MFG. APPR.	AS	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	CH	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



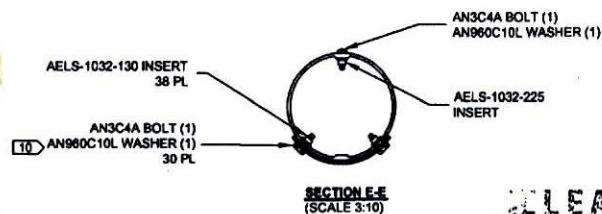
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20801AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (1/8" DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20801AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



DESIGN	Dw	DART AEROSPACE USA, INC	
DRAWN	Dw	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-12-13

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER. **REFERENCE ONLY**

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

REFERENCE ONLY

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
DATE	13.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

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